

Work Order ID 50485



Page 1

July 10, 2009 2:35:25 PM

Item ID: D3970-1KITV

Accept



Setup Start



Revision ID: A-PROTO

Item Name: Cover w/ Flashlight Holder

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3970

A-PROTO 09.06 30

100

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/14 X1
M109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA057 using tool DT9072
Dwg Rev: A
Folio Rev: A

BB 09/07/14 X1

Work Order ID 50485



Page 2

July 10, 2009 2:35:25 PM

Item ID: D3970-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Item Name: Cover w/ Flashlight Holder

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Visually inspect part for proper formation and texture	0.00							
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
140 	Hand Thermo	0.00							
Hand Finishing Thermoforming	Memo 1-Trim to finished dimensions as per Dwg	0.00							

BB 09/07/14 X1

DL 09/07/14 X1

DL 09/07/14 X1

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Start Date: 07/13/2009 Start Qty: 1.00



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Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Complete FAI document	0.00							
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
170 	Identify as per dwg & Stock Location: _____	0.00							
Packaging Packaging	Memo	0.00							

DL 09/07/15 (X1)

RU
09-07-20

PL 24-07-09

ENGINEERING
APPROVAL

FOR
ENG'G
TEST
09-07-20

ENGINEERING
APPROVAL

Work Order ID 50485

Page 4

July 10, 2009 2:35:25 PM

Item ID: D3970-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Cover w/ Flashlight Holder

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

18.09.07.20 Prototype

Picklist Print

Page 1

July 10, 2009 2:35:25 PM

Work Order ID: 50485

Parent Item: D3970-1KIVRevA-PROTO

Parent Item Name: Cover w/ Flashlight Holder

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MKYD6185S.080-P3-
62015

Purchased

No

100

sf

894.5038 3.6940



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109703

894.5037653

894.503765

See pg. 1.

DART AEROSPACE LTD	Work Order: 50485
Description:	Part Number: D3970-1K12
Inspection Dwg: D3970-1 Rev: A PROTO.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB.

Date: 09/07/16.

TRIMMING SECTION

09.07.12
↓

09.07.12

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.0 7.25	Ref	7.125"	✓			
8.2	Ref	8.2"	✓			
19.5" 19.2"	Ref	19.5"	✓			
.8"	± .100	.75"	✓			
.3"	± .010	.35"	✓			
0.045	± .010	0.053	✓			
0.030	± .010	0.036	✓			

Measured by: Whigee.

Date: 09/07/15

Audited by: PJ

Date: 09.07.20

Prototype Approval: PJ

Date: 09.07.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

D

C

B

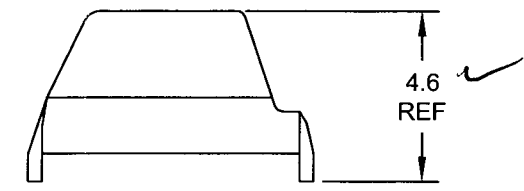
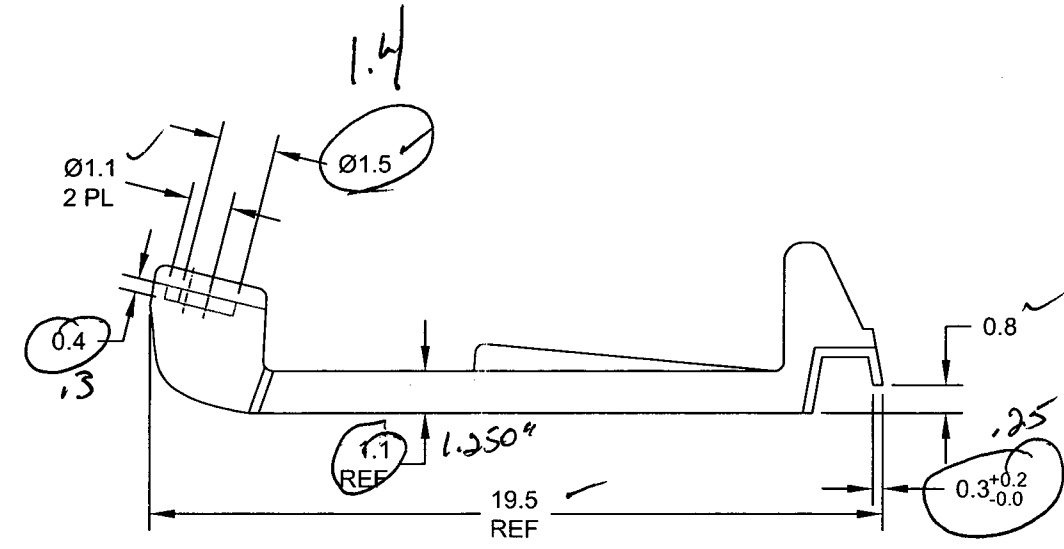
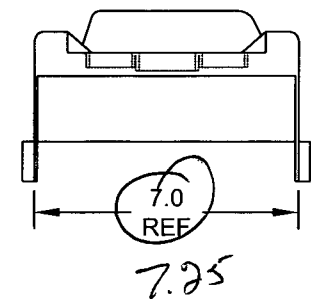
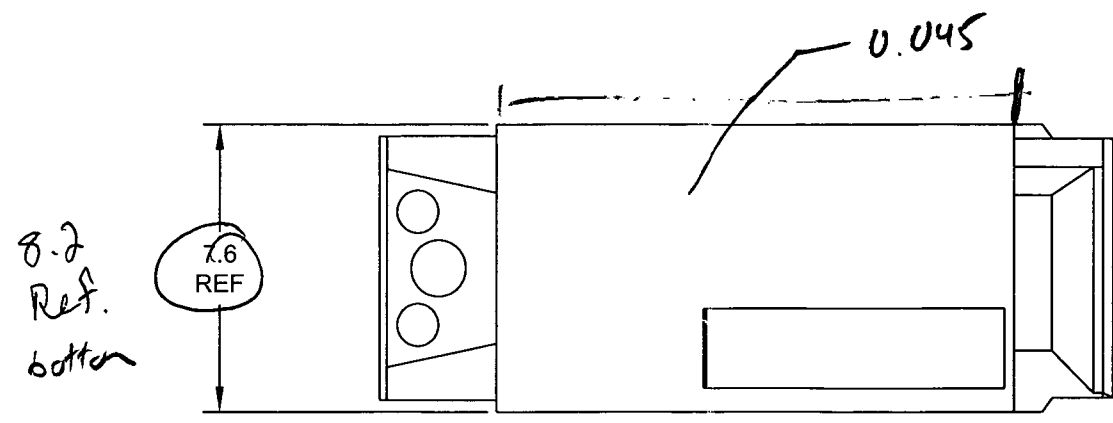
A

D

C

B

A



D3970-1 COVER, W/ FLASHLIGHT HOLDER

SUPERCEDED
09.07.14 PCH

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09-07-01 PCH

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.6 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3970-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3970-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.30
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3970	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		COVER, W/ FLASHLIGHT HOLDER	NTS
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0.030

D

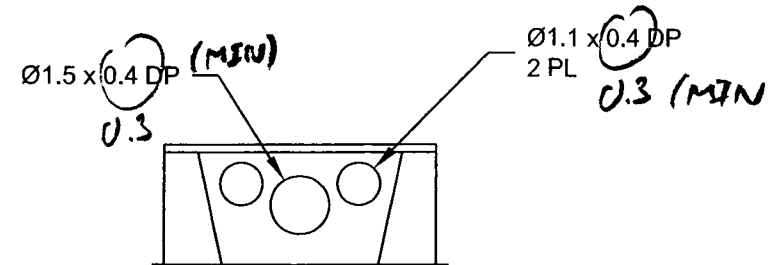
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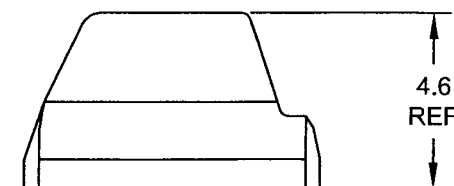
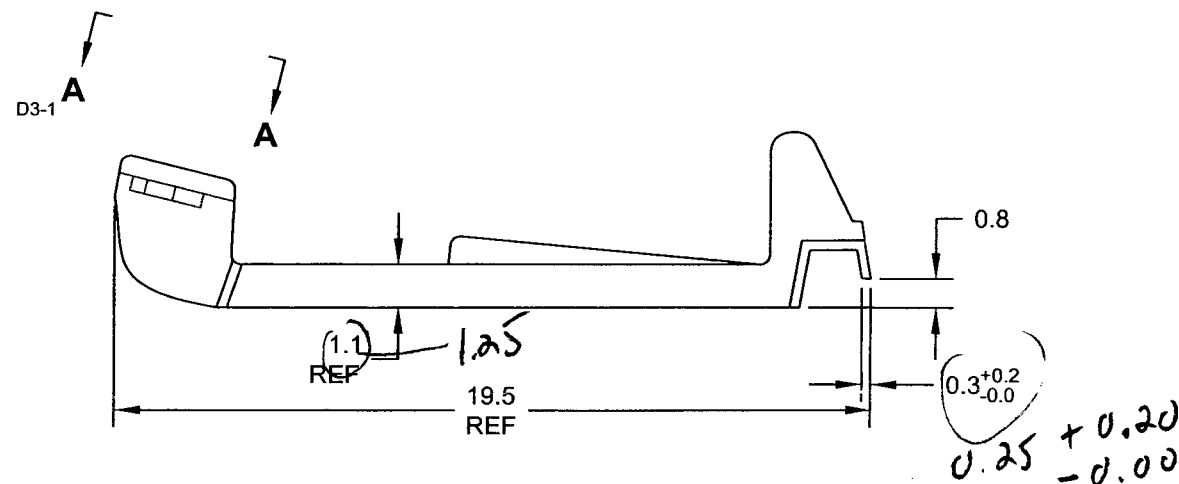
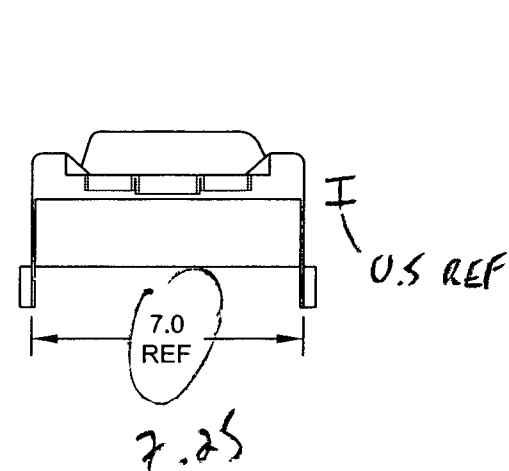
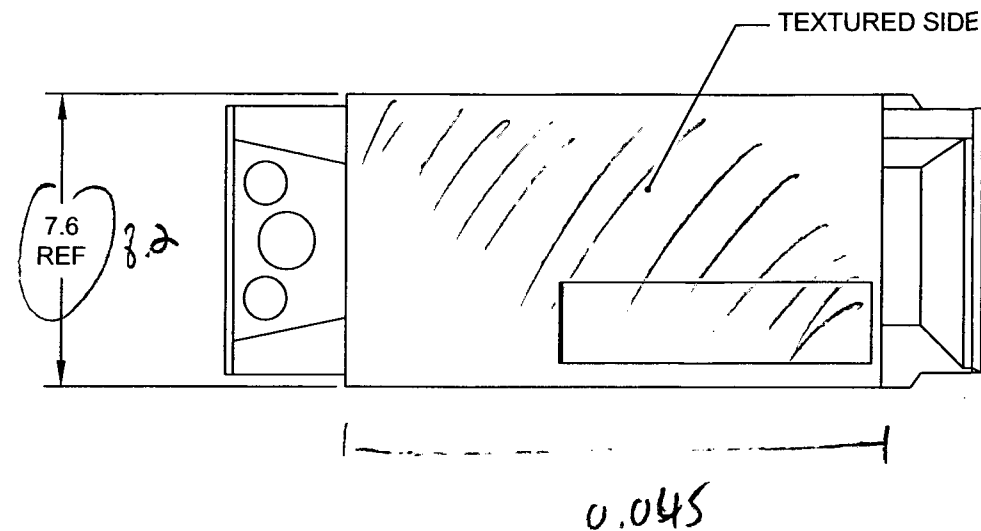
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B

B



VIEW A-A
(ROTATED CW)



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.14

D3970-1 COVER, W/ FLASHLIGHT HOLDER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9323 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3970-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3970-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3970	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		COVER, W/ FLASHLIGHT HOLDER	NTS
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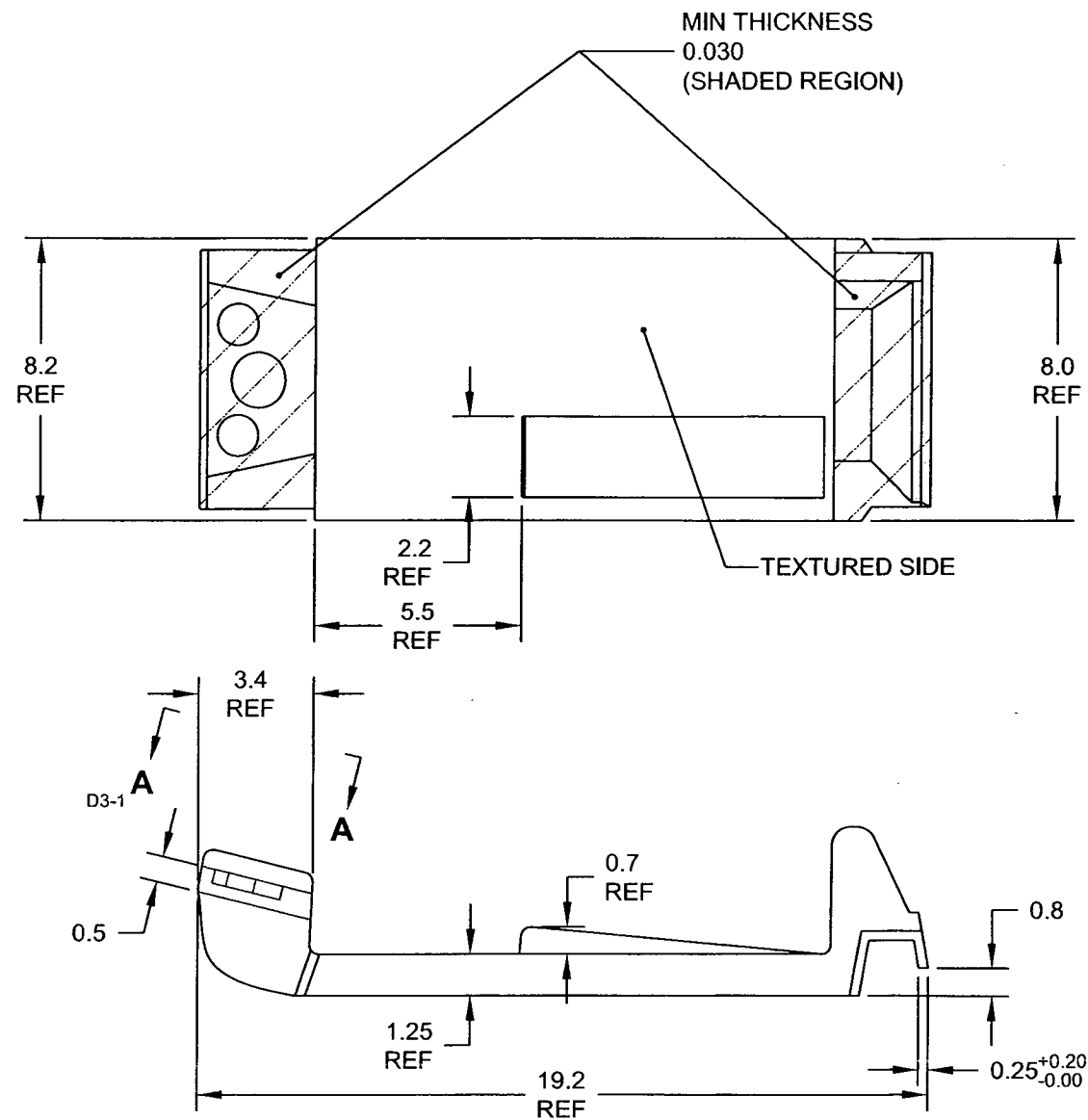
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D

C

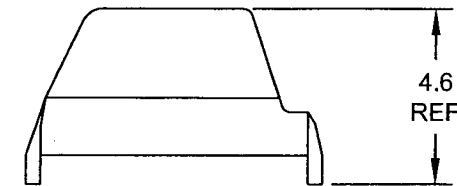
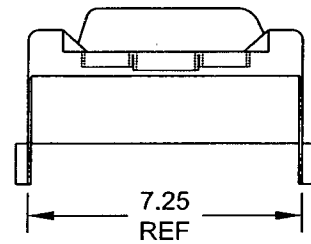
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Ø1.5 x 0.3 DP (MIN)
Ø1.1 x 0.4 DP (MIN)
2 PL

VIEW A-A
(ROTATED CW)









D3970-1 COVER, W/ FLASHLIGHT HOLDER

NOTES:

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9323 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3970-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3970-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

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